

DWS.633-011

Work Order ID 59764

Thursday, June 10, 2010 2:45:40 PM



Page 1

Item ID: D2563

Accept



Setup Start

Revision ID:

Item Name: Step Weldment Assembly

Stop

Start Date: 6/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10-6-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

10.06.19 6 8

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

6 8 BE 10/06/21

POSITIVE RECALL

EFFECTIVE *10-06-19*AUTH *u*RELEASED *u*DATE *10-06-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S10/06/21

6

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

S10 10-06-19

6

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAD

10-06-19

6

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 4

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

Powder Coating

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

ML 10 06 24 x6
11:35
350°
12:05

⑥ BK 10-6-24

190



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch

114432

0.00

— DML 10 06 24 ⑥

Memo

0.00

Hand Finishing

200



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

C. V. 6/25/10 ⑥

W/O:		WORK ORDER CHANGES					
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Thursday, June 10, 2010 2:45:40 PM



Page 5

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

PDP

0.00

Packaging

59765

220



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

C21016125

100625

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Picklist Print

Thursday, June 10, 2010 2:45:44 PM

Page 1 / 2

Work Order ID: 59764

Parent Item: D2563

Parent Item Name: Step Weldment Assembly


Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Date: 6/10/2010

Required Date: 6/18/2010


Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116  Step Extrusion		Manufactured	No			100	Each	50.0421	1	6			


Location	Loc Qty	Loc Code
WA	50.0421	
38023	0.0421	
57850	50	

6
10.06.16

D2561  Lug		Manufactured	No			100	Each	11.0000	2	12			
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Location	Loc Qty	Loc Code
WA	11	
359685	11	
58430		

6
10.06.17

D2564  Mounting Angle		Manufactured	No			100	Each	17.0000	2	12			
--	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST	17	
359686	17	
58431		

7
10.06.17

D2673-34  End Plate		Manufactured	No			100	Each	12.0000	1	6			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	12	
359690	12	
57527		

1
10.06.17

4
26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2 / 2

Work Order ID: 59764



Parent Item: D2563

Parent Item Name: Step Weldment Assembly


Start Date: 6/10/2010

Required Date: 6/18/2010

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2673-34  End Plate		Manufactured	No			150	Each	12.0000	1	6		6/10.06.22	

Location

WA

B59690
57527

Loc Qty

12

12

Loc Code

4

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

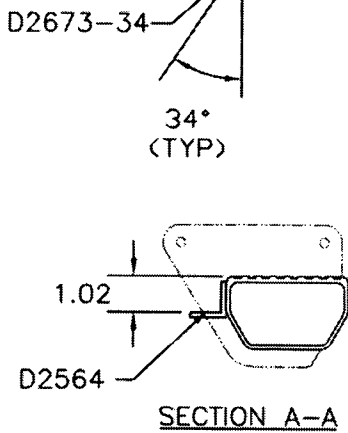
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	BW	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. C
DATE	05.11.14	TITLE	STEP WELDMENT ASSEMBLY	D2563	SHEET 1 OF 1
A	96.04.26	NEW ISSUE			SCALE 1:15
B	97.05.14	END CAPS CHANGED (WAS. D2248)			
C	05.11.14	UPDATE NOTES			



Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED
SUBJECT TO WORK ORDER
WITHOUT N
WORK ORDER
NO. 52249
P210-61c

W/O:		WORK ORDER CHANGES					
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